

Work Order ID 161060

Monday, May 08, 2017 9:08:59 AM

161060

Page 1

Item ID: PB67-43001-193

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D-Pad Base

Start Date: 5/10/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/16/2017 Req'd Qty: 6.00

6

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS 21 9-00 Date: **MAY 08 2017**

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.21

FLOW CNC Waterjet

1-Cut as per Dwg PB67-43001-193

Dwg Rev: CProg Rev: C

2-Deburr if necessary

(C) _____ 05/17/13

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(C) _____ 05/17/13

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 MAY 15 2017
130	Small Fab	0.00							
130									
Small Fab	Memo	0.10							
Small Fab	1- c'sink as per dwg. 2- Install nutplate with rivet. *** SEE DWG PB67-43001-83***								lex 17/05/15 DAS 36 9-89
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 MAY 15 2017

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: WAP03	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
3-89

MAY 16 2017

Picklist Print

Monday, May 08, 2017 9:08:58 AM

Page 1

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161060

Parent Item: PB67-43001-193

PB67-43001-193

Parent Item Name: D-Pad Base

Start Date: 5/10/2017

Required Date: 5/16/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A new issue 08.06.19 EC verified: DD
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	44.5970	0.011	0.069473			

M6061T6S 125

6061-T6 .125 Sheet

02/17/05/13

Location	Loc Qty	Loc Code
MAT019	40.2	
m136896	40.2	
MAT020	4.397	
m136327	4.397	

MS20426AD3-4

Purchased

No

130

Each

8,180.000

4

24

MS20426AD3-4

RIVET

17/05/15
DAS
36
9-89

Location	Loc Qty	Loc Code
GA	6470	
m134294	1921	
m136444	4549	
ST312	1710	
m134294	1710	

MS21075L3

MS21075L3N

Purchased

No

130

Each

4.0000

2

12

MS21075L3

Nut Plate

17/05/15
DAS
36
9-89

Location	Loc Qty	Loc Code
GA	1	
m135774	1	
ST298	3	
m135908	3	

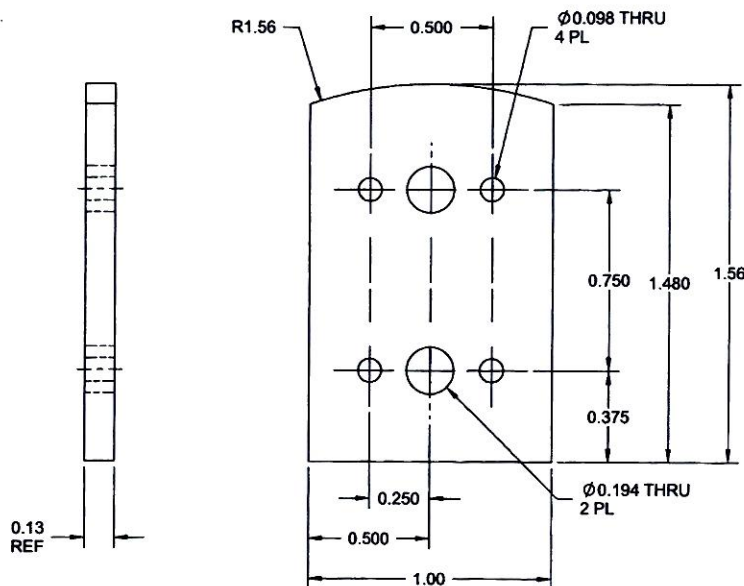
8 7 6 5 4 3 2 1

D

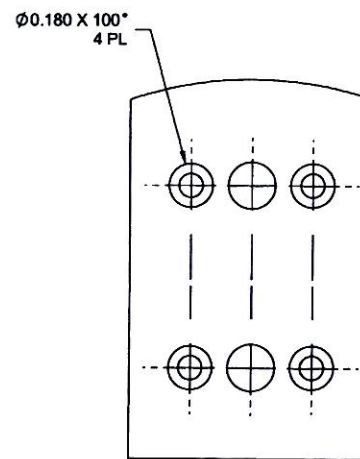
C

B

A



B67-43001-193F D-PAD BASE



B67-43001-193 D-PAD BASE
(MAKE FROM B67-43001-193)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161060 MJS
1705-08

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 25 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-193 TITLE D-PAD BASE DATE 09.03.03		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A	REV. C SHEET 1 OF 1 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

8 7 6 5 4 3 2 1